

Work Order ID 123144

Tuesday, July 29, 2014 2:32:28 PM

123144

Page 1

Item ID: D3645-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Washer

100

Start Date: 7/29/14 **Start Qty:** 15.00

~~*15*~~

Cust Item ID:

Required Date: 7/29/14 **Req'd Qty:** 15.00

~~*15*~~

Customer:

Reference:

Approvals: Process Plan: J.A.

Date: 14/07/30 Tooling: _____ Date: _____

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3645	Rev A								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 25667 Purchase Part Number: 90133a017 Supplier: MAC
MASTER CARR Certificate of conformity is required

CD 14/09/08 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

P14/9/9 100

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

DAS

38

8-89

14-9-9

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending	General	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric		Grain	Over/Under tolerance	Set-up
	Cracks		Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs		Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing		Misaligned/off center	Positioned Wrong	
	Heat Treat		Mislabeled	Power Loss/Surge	
	Inspection Strip in Tube		Misread		
	Marks/Chatter		Off-set		
	Turning Sequence		Out of Calibration		
	Wave/Twist in Tube		Out of Sequence		

Work Order ID 123144

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Item ID: D3645-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 7/29/14 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

0.00

10X

14-9-9.

DAS

26

9-89

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

MLJ 14-09-10

140

QC

Memo

0.00

Quality Control

MF
14-9-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
	Suspected Unapproved	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	<input type="checkbox"/>	
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	<input type="checkbox"/>	
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	<input type="checkbox"/>	
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	<input type="checkbox"/>	
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	<input type="checkbox"/>	
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other	<input type="checkbox"/>	
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>					
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>					
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>					
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>					

Picklist PrintPage 1
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Work Order ID: 123144

123144

Parent Item: D3645-1

D3645-1

Parent Item Name: Washer

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A New Issue 07.09.24 EC Verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
90133A017		Purchased		No		100	Each	0.0000	1	15	100		**

90133A017

WASHER

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No. _____	Suspected Unapproved			Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
				Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

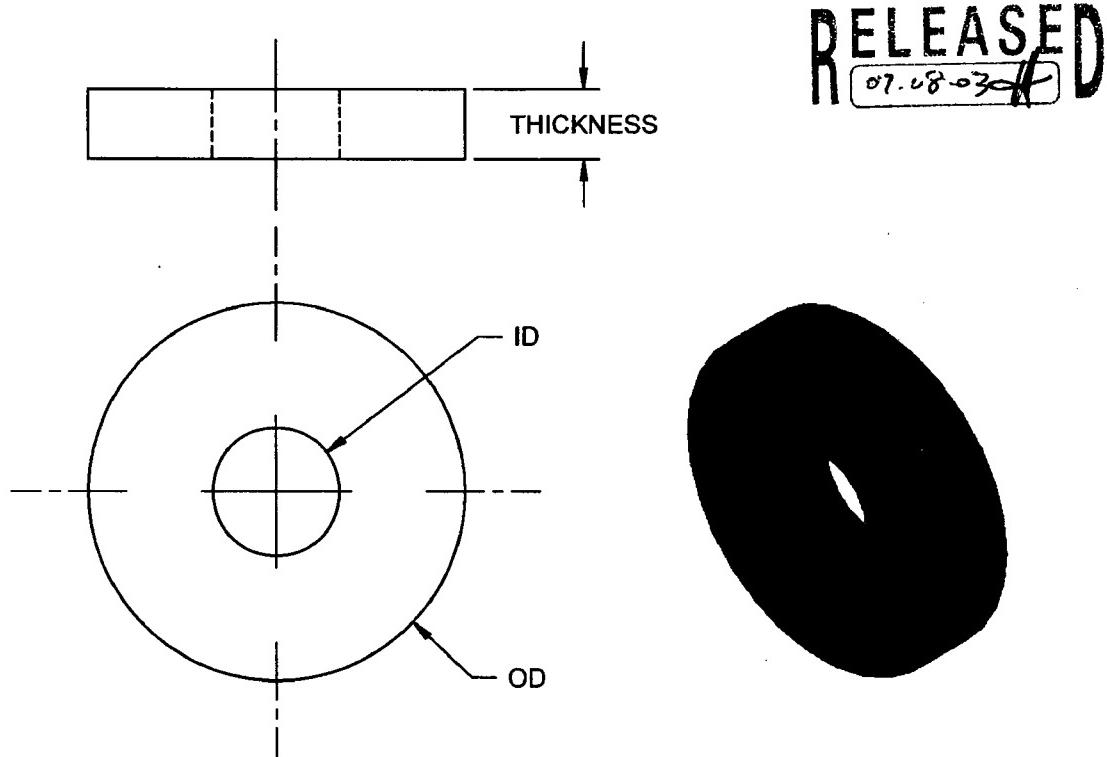
FAULT CATEGORY

Landing Gear	General				
Bending	Bend				
Centre Not Concentric	BOM/Route				
Cracks	Broken/Damage/Defect				
Crimp/Kink/Ripple/Wave	Burrs				
Cuffs	Contamination				
Crushing	Countersink				
Heat Treat	Cut Too Short				
Inspection Strip in Tube	Drawing				
Marks/Chatter	Drill Holes				
Turning Sequence	Finish				
Wave/Twist in Tube	Fit/Function				
	Folio/Program				
	Grain				
	Hardware				
	Inspection Incomplete/Unqualified				
	Instructions Incomplete/Unclear				
	Misaligned/off center				
	Mislabeled				
	Misread				
	Off-set				
	Out of Calibration				
	Out of Sequence				

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3645	REV. A SHEET 1 OF 1
DATE 07.06.21		TITLE WASHER	SCALE 4:1
REV A	DATE 07.06.21	DESCRIPTION NEW ISSUE	

J. A 14/07/20 123144

SPECIFICATION CONTROL DRAWING

P/N	ID	OD	THICKNESS	MATERIAL	SUPPLIER
D3645-1	0.17	0.50	0.09	NEOPRENE	McMASTER-CARR P/N 90133A017

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25667**

Purchase Order Date 9/8/2014

PO Print Date 9/8/2014

Page Number 1 of 2

Order From : VU-MCM001
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 10
Ship Via:	Purolator ground ppd	Currency	USD
Ship Acct:		FOB	FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	9776K93	Flame retardent nylon Hook & Loop	9/10/2014	Yes 9/10/2014	225.00 Each	\$1.63	\$365.70
	AS PER DWG D3800 REV. B COMBINATION PACK B123880 B123879						
2	90133A017	WASHER	9/10/2014	Yes 9/10/2014	100.00 Each	\$0.09	\$8.72
	AS PER DWG D3645 REV. A B123144						
						Line Total:	\$365.70
						Line Total:	\$8.72

Note:



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO25667

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Order Placed By
Chantal Lavoie

09/08/2014

McMaster-Carr Number
8619126-02

Line	Product	Ordered	Shipped
1	9776K93 Flame-Retardant Hook and Loop, 1" W X 75' L, Adhesive Back, Beige, Lengths of 75 Your Part Number: D3800 REV. B	3 Lengths	2
2	90133A017 Neoprene Rubber Washer, No. 10 Screw Size, 1/2" OD, .093" Thick, Packs of 100 Your Part Number: D3645 REV. A	1 Pack	1

LNS A81

1 - 459 - 09 43 - 84 K93 2LG 1

2 - 621 2

Shipped separately from our Chicago warehouse on 09/08

1 9776K93 Flame-Retardant Hook and Loop, 1" W X 75' L, Adhesive Back, Beige 3
Lengths 1

Dart Aerospace Ltd

EXP



4 lbs
2 lines

Me

12x12x12

FW1WBP11
09/08/2014
12:56:13:17
311
Cycle 45

